

Date: Monday, 26/05/2008 12:57:45 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : CLAMP

FOR ENGINEERING USE ONLY

Job Number : 39490

Estimate Number : 13264

P.O. Number :

Part Number : D3777041

This Issue : 26/05/2008 S.O. No. :

Drawing Number : D3777 PROTO 08.05.26

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : R & D SM/MED FAB

Drawing Revision : PROTO

Previous Run : 38602

Material :

Due Date : 28/05/2008

Qty: 2 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev.A new issue 08-05-26 DD verified by:EC

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S22GA

304/316 .032 Sheet



Comment: Qty.: 0.0210 sf(s)/Unit Total : 0.0420 sf(s)

304/316 .032 Sheet

Batch: 162159 HB 8-5-26

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3777

Dwg Rev: PREL

Prog Rev: PREL

2-Deburr if necessary

HB 8-5-26

(4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-5-26

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

08.05.02 (4)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Form as per Dwg D3777

08/05/26 (4) Hm

Date: Monday, 26/05/2008 12:57:45 PM
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Drawing Name: CLAMP

Job Number: 39490

Part Number: D3777041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

UP 08.06.04 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

FS 08/06/04 (4)

8.0

D2182B013

Rubber cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Rubber Cushion 4.000
batch: B30862

CUSHIONS
ARE
REPRESENTATIVE
UP 08.06.04

FF 08-06-05 (4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble rubber cushion as per dwg D3777

FF 08-06-05 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

UP 08.06.05 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Chris P.

00079A

UP 08.06.05 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.09 Penotype

Job Completion



mf 08-07-03

Receiving Report

Date: 6/9/22
 Supplier: COPPER BRASS

Batch No: ML2159
 Dart P/O: 2001

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☐ No ☒ N/A ☐
 QC6 Inspection u N/A ☒
 Work Order u N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606/T6S 100		96	0	0	96	

Initials of receiver (If shipment OK) Level 12 u

Production/Admin: u
 Date: 6/9/22
 Received/Costing: RCY2565
 Initial: u

Location _____

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-778

Job #: 00079

Date: 08.05.26

Product Name: Comfort Seat

Requested By: CP

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3758-041	SM	CLAMP	08.05.26	Y	08.05.28		
2	D3777-041	SM	CLAMP	08.05.26	Y	08.05.28		

COOL

OK 6545

qnn7

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

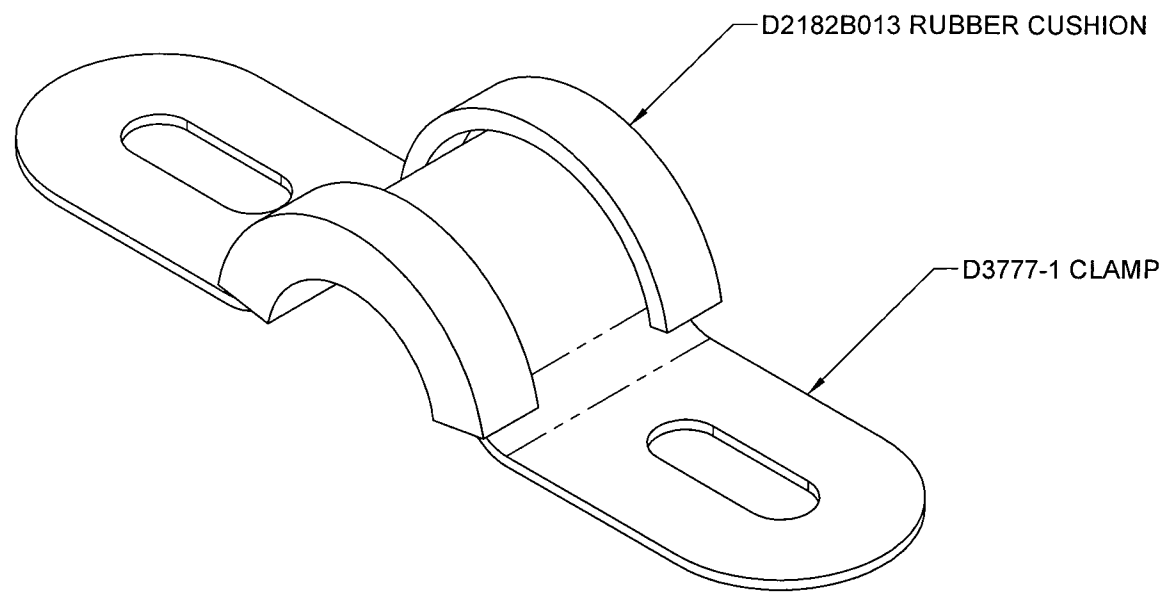
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.09	1	MAT'L CERT CALLS UP ASTM A240	CP 08.06.09 per Q51042	ASTM IS AN ACCEPTABLE SPEC FOR M304S			CP 08.06.09 per Q51042	

NOTE: Date & initial all entries

QTY	P/N	DESCRIPTION
-041		
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



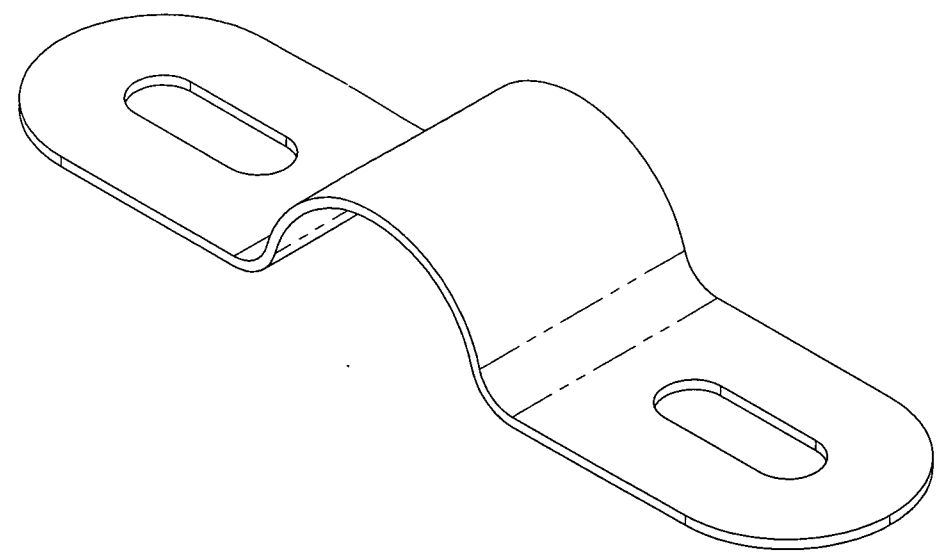
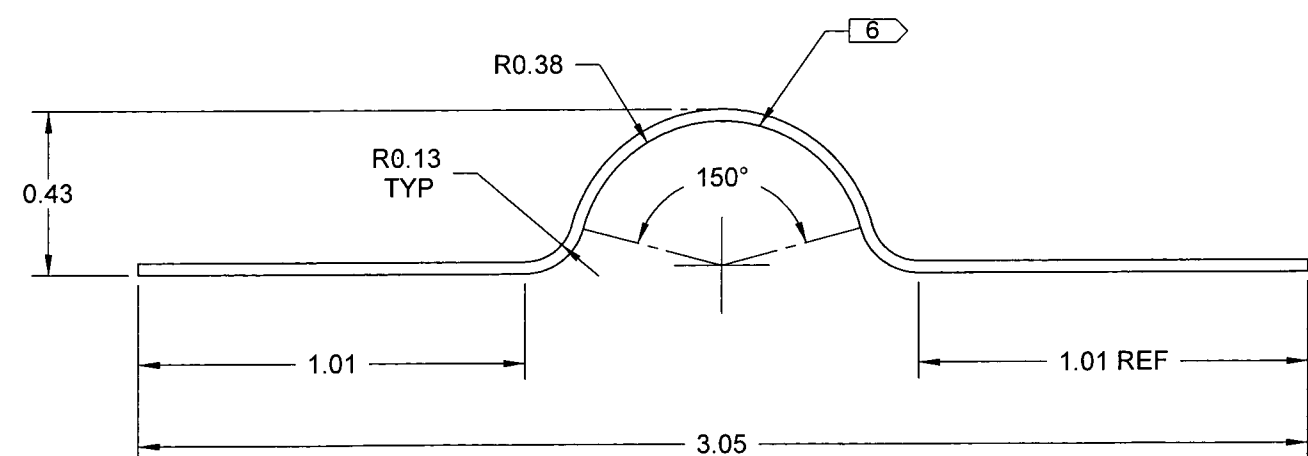
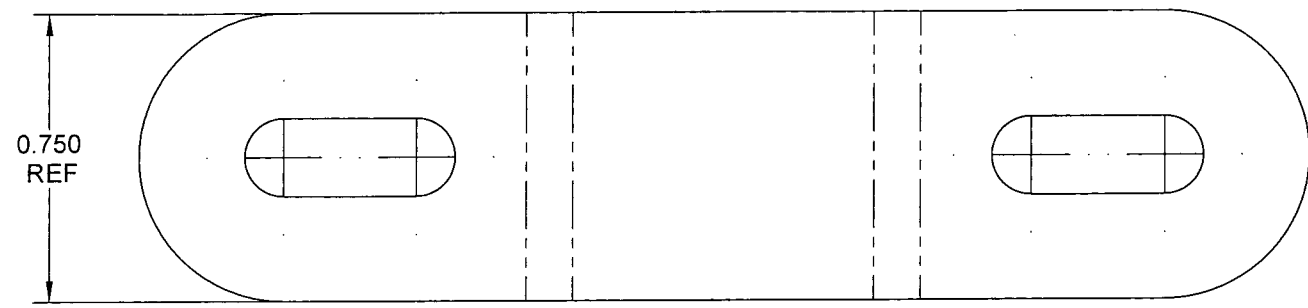
D3777-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
[Signature] 08.05.26

A	New Issue	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3777	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.04.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

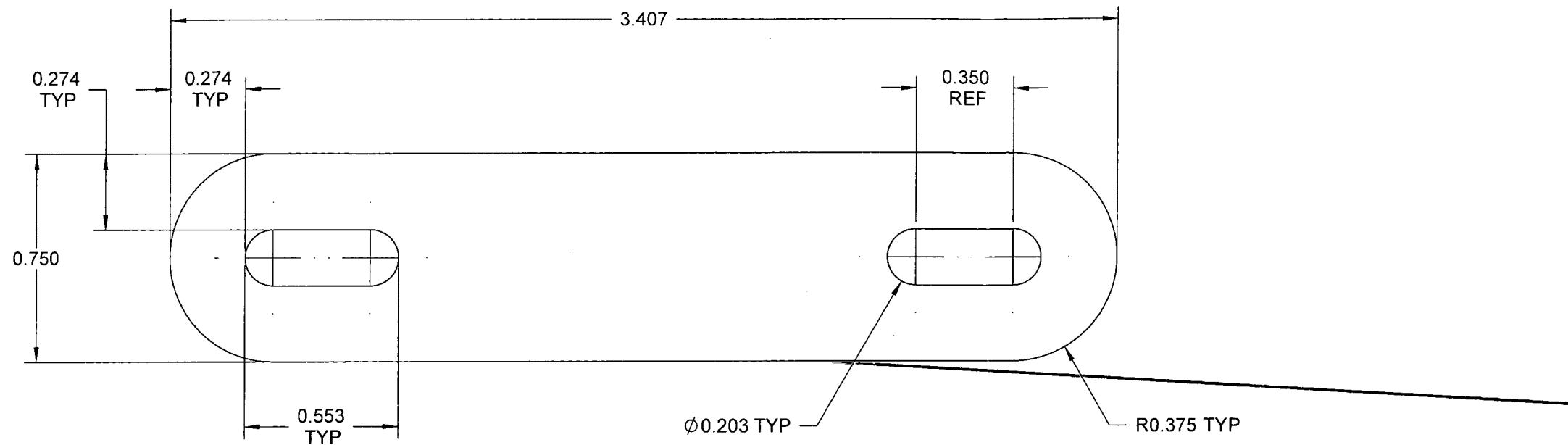


D3777-1 CLAMP

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 08.05.26

- NOTES:
- 1) MATERIAL: MAKE FROM D3777-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1" USING FINE POINT PERMANENT MARKER
 - 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3777	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE CLAMP	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	08.04.25		



D3777-1F CLAMP

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
UP 08.05.26

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.031 THICK (REF DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3777	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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